



Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200

D3245-041
Job Sheet 174767



Part No: D3245-041

Job Qty: 1 ea

Part Name: Access Panel Assembly LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 3/23/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP Rev :A New Issue 07-09-11 JLM Verified By:EC IPP Rev:b ECN 1052 07-10-31 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/22/18	0.00	0.00	Start Up Stores/Pkg-2		
100	Packaging	1 pcs		3/22/18	0.00	0.00	Packaging1-3		
110	Small Fab	1 pcs		3/23/18	0.00	0.28	Small Fab-3		
120	QC	1 pcs		3/23/18	0.00	0.00	QC5		
130	Packaging	1 pcs		3/23/18	0.00	0.00	Packaging3-1		
140	QC21-SA	1 Ea		3/23/18	0.00	0.00	QC21		

Part Op 110 - Install Nut Plates and D3245-5 angle as per Dwg D3245, follow instructions of note 8 on dwg when riveting angle, Descriptions: be careful when countersinking...mat'l very thin

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2350-18-C3Y	Rigid Receptacle	8 pcs (8 ea)	90-Start up Operation	5024833
D3245-1	Panel	1 Ea (1 ea)	90-Start up Operation	F147341
D3245-5	Door	1 Ea (1 ea)	90-Start up Operation	5047662
MS20427M3-3	Rivet	16 Ea (16 ea)	90-Start up Operation	F1134738
MS20615M3-3	Rivet	9 Ea (9 ea)	90-Start up Operation	F124859-40

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2350-18-C3Y	8	114	0
	D3245-1	1	7	0
	D3245-5	1	10	0
	MS20427M3-3	16	1,077	0
	MS20615M3-3	9	186	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																	
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																															
Part: D3245 - 041 Job No: 174767 Serial No/ Batch: S055248 Revision: _____ Inspector: _____ Date: 03/27/18				Completed By																																																															
				Lead hand / Supervisor Approval Verification																																																															
				QC / QA Coordinator Approval																																																															
				Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:30%;">Environment ☐</td> <td style="width:30%;">Use for Testing ☐</td> <td style="width:30%;">Cuffs ☐</td> <td style="width:30%;">Contamination ☐</td> </tr> <tr> <td>Design ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> </tr> <tr> <td>Material ☐</td> <td>Manufacturing Process ☐</td> <td colspan="2" rowspan="3" style="vertical-align: top;">OTHER : _____</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Past Due ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td></td> </tr> <tr> <td>LOA ☐</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Substation ☐</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Past Expiry Date ☐</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td></td> <td></td> <td></td> </tr> </table>		Environment ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Design ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Doc/Data ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Equip/Tooling ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Handling/Pre ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Material ☐	Manufacturing Process ☐	OTHER : _____		Internal Transport ☐	Past Due ☐	Tribal Knowledge ☐		LOA ☐				Substation ☐				Past Expiry Date ☐				Misidentified ☐				<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:30%;">Power Loss/Surge ☐</td> <td style="width:30%;">Positioned Wrong ☐</td> </tr> <tr> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>		Power Loss/Surge ☐	Positioned Wrong ☐	Folio/Program ☐	Outside Dimensions ☐	Grain ☐	Over/Under tolerance ☐	Weld ☐	Part Incorrect ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Out of Sequence ☐	Part Moved ☐	Off-set ☐	Drawing ☐	Mislabeled ☐	Finish ☐
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